

Date: Tuesday, 19/08/2008 4:04:22 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 41440		
Estimate Number	: 10832		
P.O. Number	:	Part Number	: D29322
This Issue	: 19/08/2008	Drawing Number	: D2932 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: //	Drawing Revision	: C
Previous Run	: 40280	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <u>JUL 08-8-19</u>	Qty:	6 Um: Each
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	Saddle Billet, 7075
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: <u>B34873</u> <i>ml 08/08/27</i> (6)		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr <i>ml/J.F. 08/08/28</i> (6)		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <i>ml/J.F. 08/08/28</i> (6)		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET <i>ml/J.F. 08/08/28</i> (6)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:22 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 41440

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JP 08/08/21 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JP

08/08/28 (6)

7.0

POWDER COATING

POWDER COATING



M 108 523



(6K)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:20

OVEN TEMPERATURE:

320°C

FINISH TIME:

10:50

M-J 08/09/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-02 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 428

JP 08/09/02 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03 JP

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41440
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.115	.127"	.126"	.126"		
B	0.100	0.140		.116	.128"	.124"	.127"		
C	0.100	0.140		.116	.125"	.124"	.124"		
D	0.210	0.230		.223	.225"	.224"	.225"		
E	1.245	1.255		1.250	1.251"	1.251"	1.251"		
F	1.245	1.255		1.250	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500	2.501"	2.501"	2.501"		
H	0.510	0.515		.516	.510"	.510"	.510"		
I	1.572	1.582		1.575	1.578"	1.578"	1.578"		
J	2.495	2.505		2.500	2.502"	2.502"	2.502"		
K	0.257	0.262		.259	Ø.258"	Ø.258"	Ø.258"		
L	0.312	0.317		.314	Ø.313"	Ø.313"	Ø.313"		
M	0.235	0.240		.238	.238"	.238"	.238"		
N	0.100	0.140		.118	.120"	.120"	.120"		
O	0.540	0.560		.546	.548"	.550"	.550"		
P	0.490	0.510		.501	.501"	.501"	.504"		
Q	3.715	3.725		3.717	3.723"	3.723"	3.723"		
R	2.470	2.510		2.490	2.493"	2.493"	2.493"		
S	0.240	0.270		.254	.256"	.256"	.255"		
T	0.100	0.180		.140	.140"	.140"	.140"		
U	1.625	1.635		1.629	1.629"	1.629"	1.629"		
V	1.362	1.372		1.367	1.368"	1.368"	1.368"		
W	0.316	0.321		.320	Ø.320"	Ø.320"	Ø.320"		
X	1.125	1.145		1.135	1.134"	1.134"	1.134"		
Y	1.565	1.585		1.574	1.574"	1.574"	1.574"		
Z	0.178	0.198		.188	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ml / J.F.</i>
Date: 08/08/28

Audited by: <i>SL</i>
Date: 08/08/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 41440
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

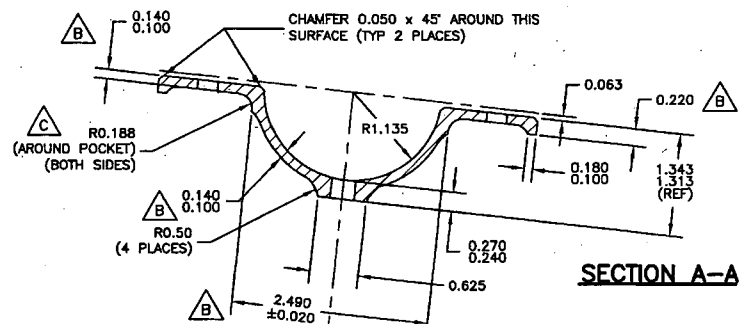
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	3	4		
A	0.100	0.140		.125"	.126"				
B	0.100	0.140		.126"	.126"				
C	0.100	0.140		.125"	.125"				
D	0.210	0.230		.226"	.224"				
E	1.245	1.255		1.251"	1.251"				
F	1.245	1.255		1.250"	1.250"				
G	2.495	2.505		2.501"	2.501"				
H	0.510	0.515		.510"	.510"				
I	1.572	1.582		1.578"	1.578"				
J	2.495	2.505		2.502"	2.502"				
K	0.257	0.262		0.258"	0.258"				
L	0.312	0.317		0.313"	0.313"				
M	0.235	0.240		.238"	.238"				
N	0.100	0.140		.121"	.119"				
O	0.540	0.560		.548"	.548"				
P	0.490	0.510		.504"	.504"				
Q	3.715	3.725		3.723"	3.723"				
R	2.470	2.510		2.493"	2.493"				
S	0.240	0.270		.255"	.255"				
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W	0.316	0.321		0.320"	0.320"				
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Y	1.565	1.585		1.576"	1.574"				
Z	0.178	0.198		0.188"	0.188"				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

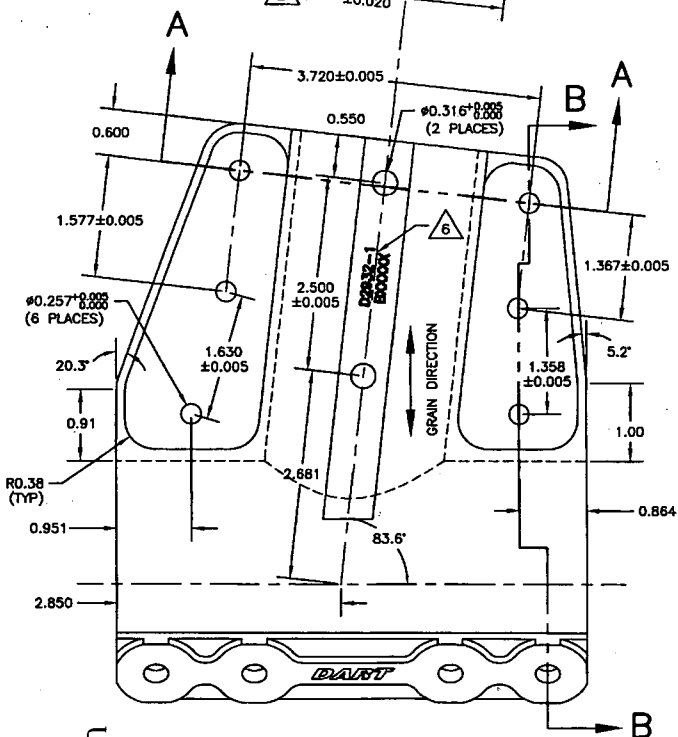
Measured by: J.F.
Date: 08/08/28

Audited by: [Signature]
Date: 08/08/28

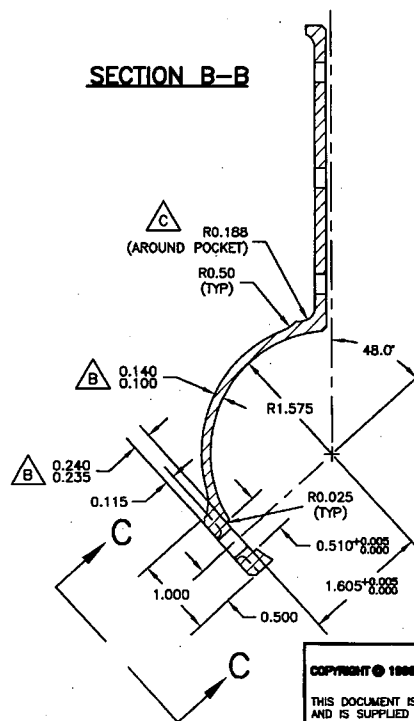
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]



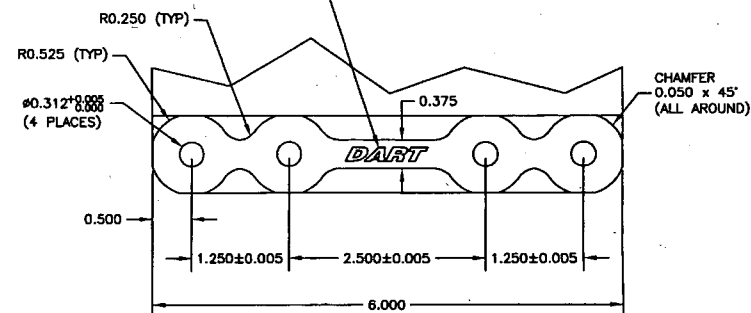
SECTION A-A



SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLEVUE, VA
CHECKED	PH	DRAWING NO. D2932
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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